

Work Order ID 71547

Wednesday, July 06, 2011 11:32:40 AM



Page 1

Item ID: D350-591-121

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, LH

Start Date: 7/6/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2351	Rev E								

100

0.00



DOCUMENT CONTROL

7

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

Subtotal 7

for BG 11-8-17

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

11-07-07
11-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bender 1

Memo

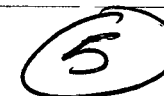
0.00

CNC Delta 100 Bender

Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.



11-8-2



130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublog



140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033
A/RAluminum Rod M117884

3-Do not Grind Flush

11-08-10
MAE

5

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

+ 5 0 BE 11/08/11

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S wlosly

(x5) LH

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H/A

11.08.11

(x5) /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
190 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Rivet Leg Assembly as per Dwg D2351								
	2-Weld Fwd End Plate per QSI 004 & Dwg D2351								
	A/RAluminum Rod <i>1114703</i>								
	3-Grind end cap flush per dwg D2351								
220 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							

SAD 11-09-912

(X5)

11/11/13

Sulostis

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

240 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

250 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:50
320°F
4:20

25
24

SX Ø m-11/08/05

SX Ø m-11/08/05

M118434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 6

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Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

Wing Walk as per dwg QSI005 4.4 Batch

0.00

M 118313



HandFinish

Memo

0.00

Hand Finishing

5X ~~Ø~~ M-11/08/16

270

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 u/08/17

x5
LH

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/17 ~~Ø~~ (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

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Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	Subtotal >			XS LH			
300 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-591-121 Location: <u>80</u> PPP Rev: <u>E</u>	0.00 0.00				11/8/17		(52)	
310 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				11/8/18		(5)	

H11-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:32:38 AM

Page 1

Work Order ID: 71547

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev: E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2850-1 		Manufactured	No			140	Each	0.0000	1	5			
End Bracket													
D2582 		Manufactured	No			190	Each	0.0000	1	5			
Step Leg Assembly													
MS20600-AD4W3 		Purchased	No			190	Each	895.0000	16	80			
Cherry Rivets													

11.08.10 B68490

11.08.10 B ~~68490~~

71386 (x4)
+1 B72739

MA

Location	Loc Qty	Loc Code
ST321	762	
111636	112	
117505	496	
117601	154	
WA018	133	
107939	133	

(x63)
(x17)

D2673-34 	Manufactured	No
End Plate		

210	Each	99.0000	1	5
-----	------	---------	---	---

11.08.12

Location	Loc Qty	Loc Code
WA	76	
69534	76	
WA015	23	
59690	23	

5

Jul 11.07.07

D2244-116.

EXTRUSION. Qty 1

WA B60307 (2.5)
11.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 71547

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 5.00

Required Qty: 5.00

AN4-16A

Purchased No

290 Each

186.0000 2

10



Bolt

Location

Loc Qty

Loc Code

ST358

186

116400

2

~~117514~~

84

117872

100

D2856-400

Manufactured No

290 f

111.5896 0.6

3



Abraison Strip

Location

Loc Qty

Loc Code

ST403

110.92

68076

110.92

ST409

0.6696

63735

0.6696

cut (1) at 7.20"

AN960JD416

NAS1149D0463J

Purchased No

290 Each

0.0000 6

30 12x

18x



Washer

D2230-1

Manufactured No

290 Each

199.0000 1

5



Lug

Location

Loc Qty

Loc Code

ST470

1

54755

1

ST476

198

67826

6

69179

92

69821

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, LH

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 5.00

Required Qty: 5.00

AN3-37A

Purchased

No

290

Each

217.0000

2

10



Bolt

Location

Loc Qty

Loc Code

ST353

167

105425

31

111668

136

ST354

50

117619

50

MS21042L3

Purchased

No

290

Each

1,875.000

2

10



Nut

Location

Loc Qty

Loc Code

ST300

1875

116549

201

117441

800

117601

400

117885

474

AN4-13A

Purchased

No

290

Each

872.0000

3

15



Bolt

Location

Loc Qty

Loc Code

ST357

872

117962

272

118078

600

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Parent Item Name: Heli-Access-Step, LH

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

290

Each

4,568.000

3



Nut

Location

Loc Qty

Loc Code

ST300

4568

117441

2279

117601

789

117885

1500

D2230-3

Manufactured

No

290

Each

202.0000

1



Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST

120

70694

120

ST476

78

53881

4

69820

74

D2732-030

Manufactured

No

290

Each

6.0000

2



Rubber Cushion

Location

Loc Qty

Loc Code

ST402

6

69205

6

Cut (2) at 3.00"

AN960JD10

NAS1149D0363J

Purchased

No

290

Each

0.0000

4



Washer

Wednesday, July 06, 2011 11:32:38 AM

Shop Packet Print

Page 4

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DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2351	REV: E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71547

C2 L110 7106

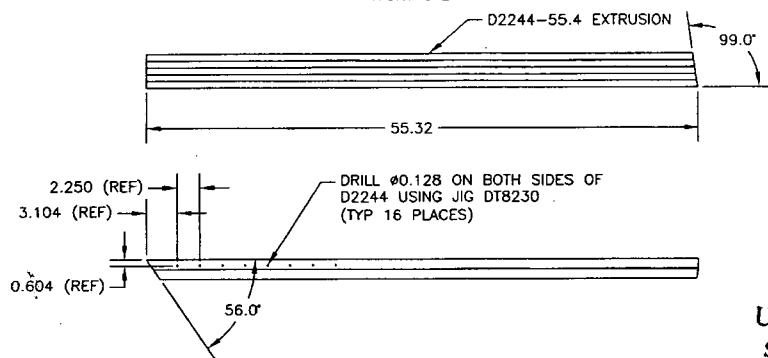
RELEASED
05.11.28 H

PH
ECN 1105
UNDER REVIEW
07.11.29 H
PER NCR # 263

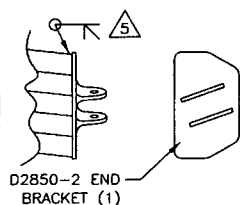
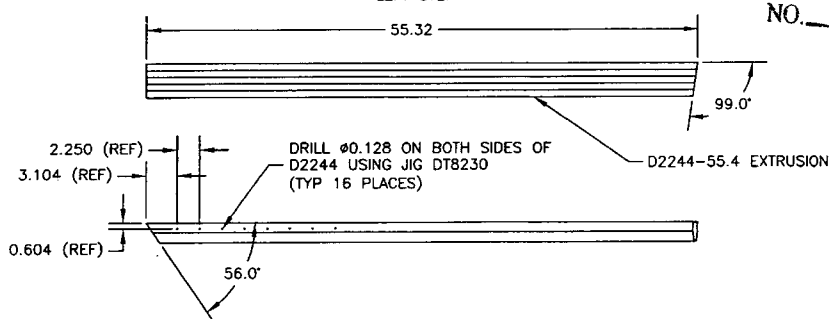
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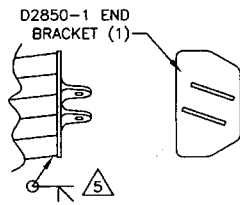
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



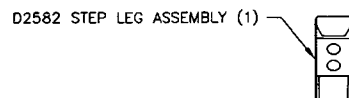
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



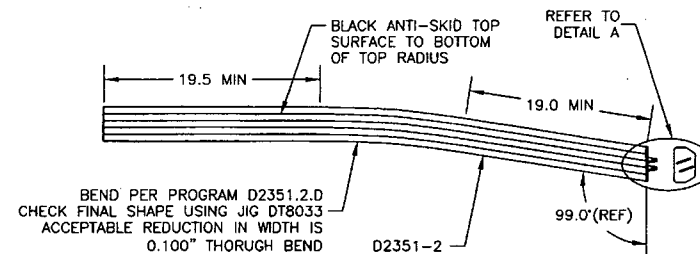
DETAIL B
SCALE: 1:4



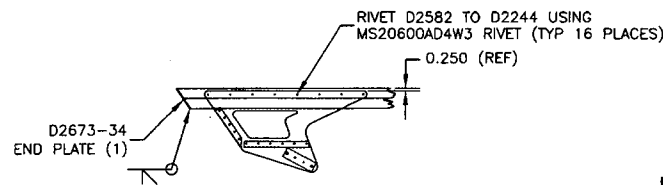
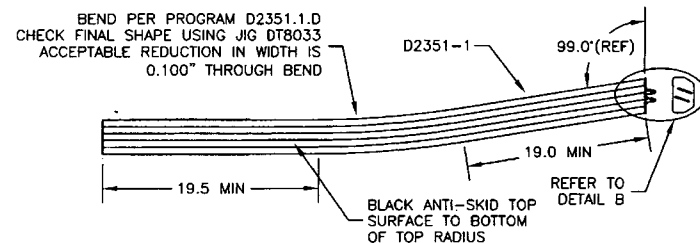
GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) CHAMFER D2244 EXTRUSION 0.075"x45' BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

COPYRIGHT © 1995 BY DART AEROSPACE LTD.		DESIGN KE		DRAWN BY PH		DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #		APPROVED #		DRAWING NO. D2351	
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY		REV. E SHEET 2 OF 2		SCALE 1:12	

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	Heli-Access-Step ™, Long Step – High Skid
	X					D350-591-113	Heli-Access-Step ™, Short Step – High Skid
		X				D350-591-115	Heli-Access-Step ™, Short Step – Low Skid
			X			D350-591-117A	Heli-Access-Step ™, Pre-Flight Step
				X		D350-591-119	Heli-Access-Step ™, Long Step – Low Skid
					X	D350-591-133	Heli-Access-Step ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-122	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-123	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-124	Heli-Access-Step ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G

Date: 08.10.06

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:


ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT







The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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